

Work Order ID 59448

Friday, June 04, 2010 11:24:57 AM



Page 1

Item ID: D5957

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, 205

Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-6-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5957

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5957, Ensure Batch Number is entered
Keyway 3-Deburr & Tumble

[Signature] 10/06/26

6 *0*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

[Signature] 10/06/26

6 *0*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S.F. 10/06/28

8 *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59448

Friday, June 04, 2010 11:24:57 AM



Page 2

Item ID: D5957

Accept



Setup Start



Revision ID:

Item Name: Saddle, 205

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		HL 10/06/28		6	0		
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 10:15 OVEN TEMPERATURE: 320° FINISH TIME: 10:45	0.00 0.00				6			bl 10-6-28
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							10 06 28 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59448

Friday, June 04, 2010 11:24:57 AM

Page 3

Item ID: D5957

Accept

Revision ID:

Item Name: Saddle, 205

Start Date: 6/4/2010 Start Qty: 6.00

Required Date: 6/10/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 430

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C10/6/28 *(S)*

10/06/29

MF

10-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 11:25:02 AM

Page 1

Work Order ID: 59448



Parent Item: D5957



Parent Item Name: Saddle, 205

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			110	Each	52.0000	1	6			



Saddle Billet



Location

Loc Qty

Loc Code

MAT42

52

46412

2

58677

50

6-10/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59448
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				#By	#Date
				1	2	3	4		
A	0.438	0.443		0.441	0.441	0.441	0.441	5	6
B	1.745	1.755		1.750	1.750	1.750	1.750	5	6
C	5.245	5.255		5.250	5.250	5.250	5.250	5	6
D	6.995	7.005		7.000	7.000	7.000	7.000	5	6
E	5.240	5.260		5.250	5.250	5.250	5.250	5	6
F	4.745	4.755		4.750	4.750	4.750	4.750	5	6
G	0.315	0.322		0.321	0.321	0.321	0.321	5	6
H	1.522	1.532		1.527	1.527	1.527	1.527	5	6
I	3.048	3.058		3.053	3.053	3.053	3.053	5	6
J	4.575	4.585		4.580	4.580	4.580	4.580	5	6
K	0.315	0.322		0.321	0.321	0.321	0.321	5	6
L	0.495	0.505		0.500	0.500	0.500	0.500	5	6
M	0.490	0.510		0.501	0.501	0.501	0.503	5	6
N	1.865	1.885		1.879	1.879	1.879	1.879	5	6
O	7.990	8.010		8.002	8.002	8.002	8.002	5	6
P	2.240	2.260		R2.25	R2.25	R2.25	R2.25	5	6
Q	0.308	0.313		0.310	0.310	0.310	0.311	5	6
R	0.760	0.765		0.764	0.764	0.764	0.764	5	6
S	0.490	0.510		0.491	0.495	0.490	0.494	5	6
T	1.625	1.645		1.635	1.629	1.630	1.632	5	6
U	2.000	2.020		2.008	2.006	2.007	2.008	5	6
V	0.023	0.043		0.033	0.033	0.033	0.033	5	6
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	DT
Date:	10/06/26

Audited by:	DT
Date:	10/06/28

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

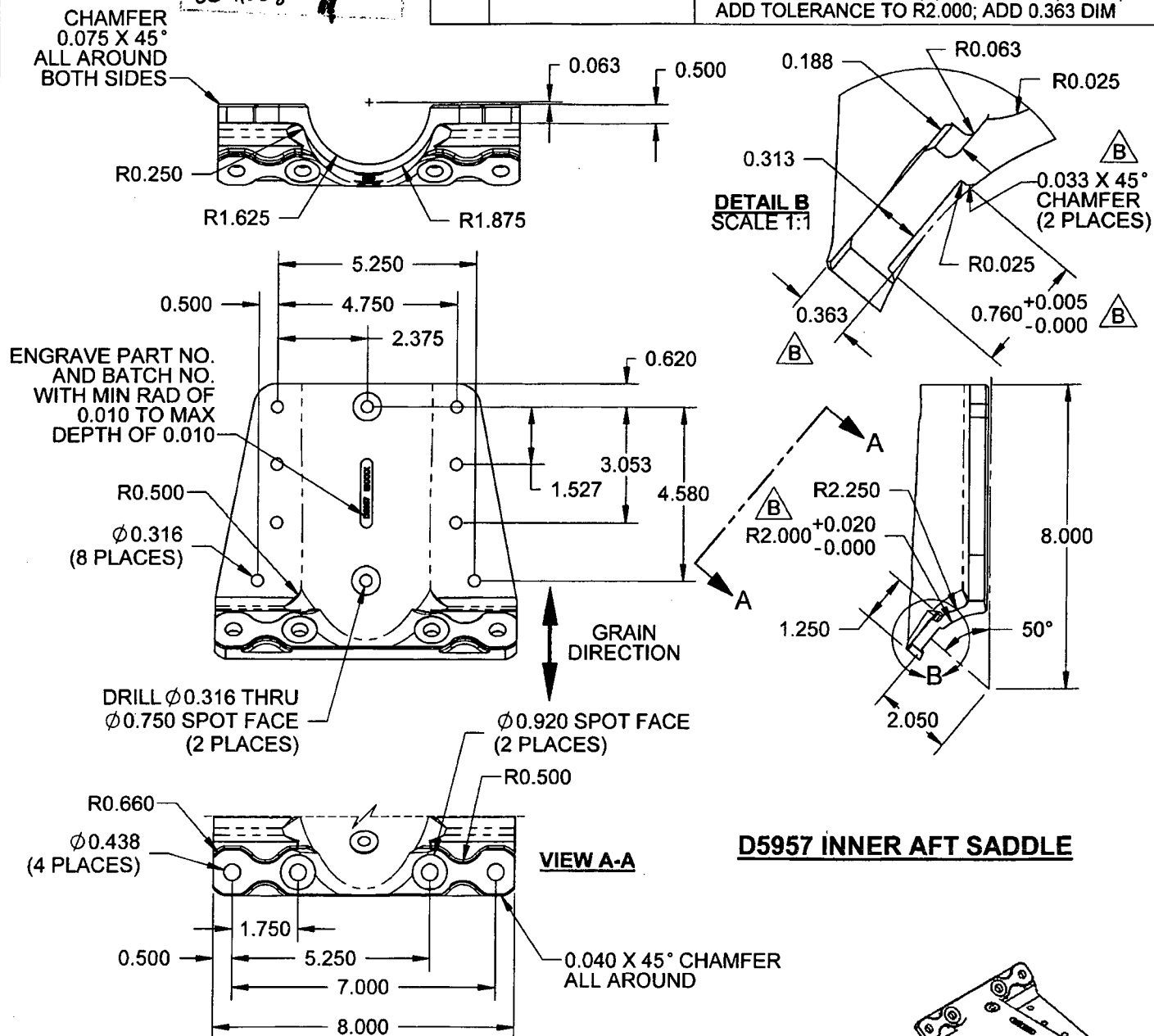
SUBJECT TO A

WITHOUT
WORK

NO. 59448
3-10-6-04

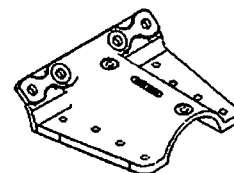
DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020



ISOMETRIC VIEW
SCALE 1:8

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolutions: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries